

Date: Tuesday, 12/11/2007 10:25:58 AM  
 User: BOSS Admin

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PATIENT STOP
Job Number	: 36243		
Estimate Number	: 11490		
P.O. Number	: <i>N/A</i>	Part Number	: D2492
This Issue	: 12/11/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2492 REV F
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 12/10/2007 Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 25271	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i> 07-12-11	Due Date	: 12/24/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	16 Um: Each
Comment	: Est. E 00.06.26 Removed P/O for powder coat EC Est Rev.F Now 6061-T6. 06-06-23 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.9140 sf(s)/Unit Total : 30.6247 sf(s)  
 6061-T6 .080 Sheet  
 Material: 6061-T6 0.080" thick  
 (M6061T62S.080)  
 Batch *106320* *HB 07-12-11*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2492  
 Dwg Rev: *F* *HB 07-12-11*  
 Prog Rev: *F*  
 2-Deburr if necessary *HB 07-12-11*



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*counts*  
*5 07-12-11* *(16)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Deburr  
 Form using Jig DT2492B

*SAD 08-01-03*

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 36243

Part Number: D2492

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 (16)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(alodine) M-1  
acid etch: Alodine  
M 106379  
BP 08-01-08  
08/01/08 (16X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1  
08/01/08 (16X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 189

AS 08/01/08 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(16)  
08/01/08

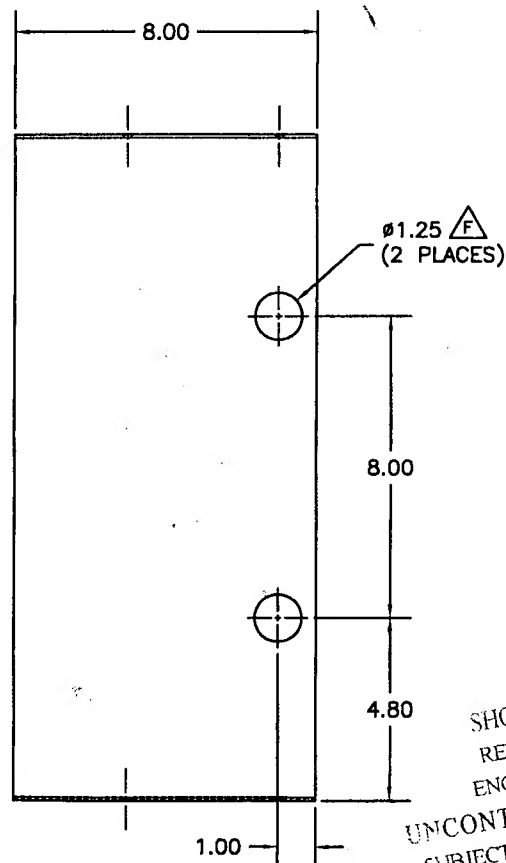
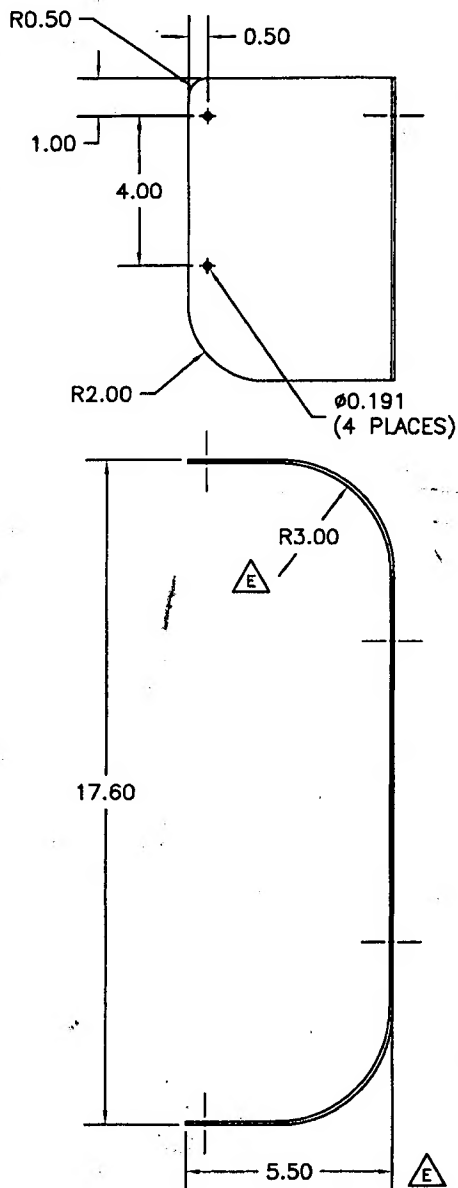
Job Completion



U 08-01-09

**DART**

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 36243

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